

## **METHOD FOR FABRICATING BOTTLE MOLDS**

### **ABSTRACT OF THE DISCLOSURE**

The method allows fabricating a bottle mold having dissimilar metal inserts embedded in regions where the bottle mold is most subject to attack by hot glass, and has a glass contact surface with refined grain size. To fabricate the bottle mold, rough castings are made by pouring cast-iron into a composite mold having dissimilar metal insert blanks fixably positioned therein. The dissimilar metal insert blanks become embedded in the cast-iron matrix to form rough dissimilar metal inserts in the rough casting. The composite mold has regions formed by metal chills that are partially embedded in a sand mix. The chills and the exposed surfaces of the rough dissimilar metal inserts define a cavity surface of the rough casting, which is subsequently machined to provide the glass contact surface of the bottle mold. The chills refine the grain size of the cast iron at the glass contact surface.